

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010405**Date Inspected:** 22-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chung Ging**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY #10

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT # 4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 056200 performing Shielded Metal Arc Welding process for the weld SSTL4-1B/C-2A located on PCMK corner weld between skin plate E and skin plate D of south tower lift #4. ZPMC QC Mr. Du Zhi Qun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair.

NORTH TOWER LIFT #4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201825 performing Flux Cored Arc Welding process for the weld NSTL4-3B/L-54 located on PCMK north tower lift #4. ZPMC QC Mr. Wang Chung Ging monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

WELDING INSPECTION REPORT

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052075 performing Flux Cored Arc Welding process for the weld NSTL4-3C/L-129 located on PCMK north tower lift #4. ZPMC QC Mr. Wang Chung Ging monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057244 performing Flux Cored Arc Welding process for the weld NSTL4-3F/L-65 located on PCMK north tower lift #4. ZPMC QC Mr. Wang Chung Ging monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Cored Arc Welding process for the weld NSTL4-3G/L-64 located on PCMK north tower lift #4. ZPMC QC Mr. Wang Chung Ging monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050041 performing Flux Cored Arc Welding process for the weld NSTL4-3H/L-62 located on PCMK north tower lift #4. ZPMC QC Mr. Wang Chung Ging monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

TRIAL ASSEMBLY YARD

OBSERVATION

OBG SEGMENT 1BW- 1AW

During the random visual inspection this Quality Assurance (QA) Inspector observed the bottom panel splice weld between OBG segment 1AW and 1BW excavated various location.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Utekar,Shrikant | Quality Assurance Inspector |
| Reviewed By: | Dawson,Paul | QA Reviewer |
